

Date: Monday, 2/4/2008 11:28:00 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CHAFING SHIELD
Job Number : 37185	
Estimate Number : 10840	
P.O. Number :	Part Number : D31891
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D3189 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/	Drawing Revision : B
Previous Run : 36065	Material :
Written By : <u>08 02 04</u>	Due Date : 2/11/2008 Qty: <u>10</u> Um: Each
Checked & Approved By : <u>08 02 04</u>	
Comment : Est. B 05.08.22 No longer made in-house KJ/JLM	
Est Rev:C 06-03-24 Rolling Now made in House JLM	
Est Rev:D 07-04-16 As per Rev B JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.3360 sf(s)/Unit Total: 3.3600 sf(s)  
 304/316 SS .020" Sheet  
 (M304S25GA)  
 Batch: M104933

M10702 (37) M10559 (14)  
08/02/07

2.0	SHEAR	SHEAR
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Comment: SHEAR  
 Cut to size as per Dwg D3189

08/02/07 (10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Deburr & Grind Rads as per Dwg D3189  
 2-Roll as per Dwg D3189

08/02/07 (10)  
MF 08-02-20

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 08/02/20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: Crosslake part

SB 08/02/20 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.02.07	1	ACCEPTABLE TO USE M304S26 GA B/N <u>M107021(3x)</u> M105592019 CP MEASURED MAT'L THICKNESS IS 0.018-0.019				CP 08.02.07 pc Q51042	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		<del>NEED TO USE M304S26 GA MAT'L (25 GA RAN OUT)</del>		<del>ACCEPTABLE</del>				

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:28:00 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CHAFING SHIELD

Job Number: 37185

Part Number: D31891

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

Done 10/2/22

Job Completion



2008/2/20

(10)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

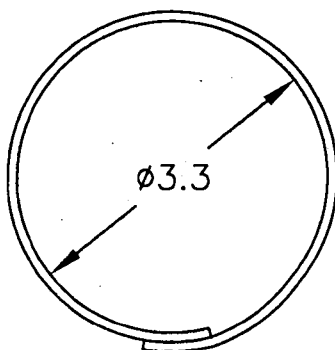
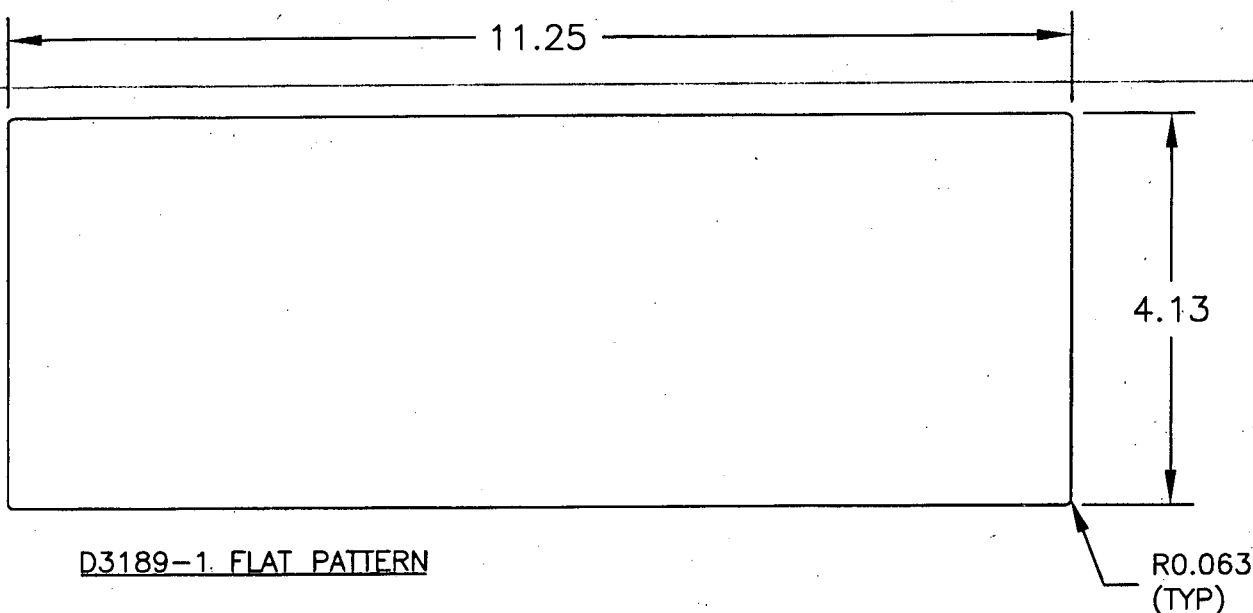
**NOTE:** Date & initial all entries

**DART**

DESIGN	QP	DRAWN BY	QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE	07.01.05			TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08			NEW ISSUE	
B	07.01.05			ADD -3	

**RELEASED**

07.03.27



D3189-1 ROLLING DETAIL  
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE  
WORK ORDER  
NO. 37185

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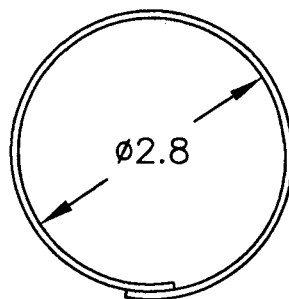
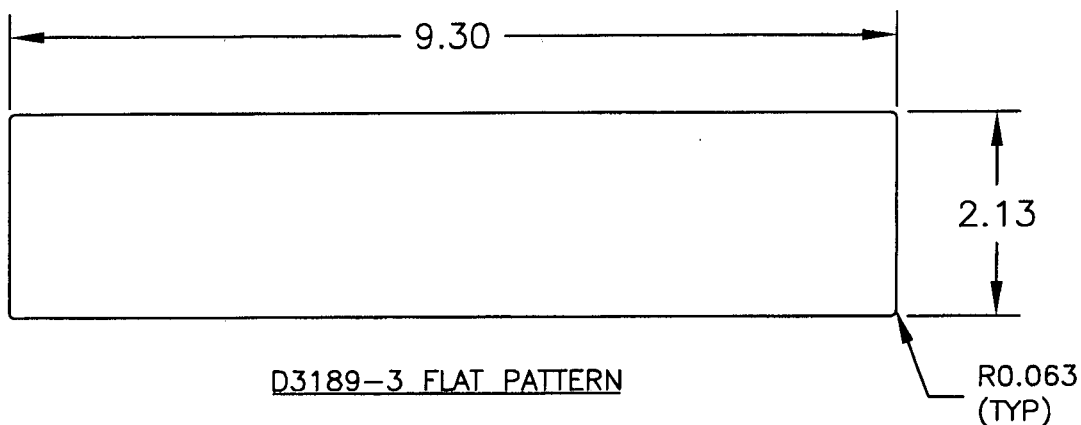
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**DART**

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 [Signature]



D3189-3 ROLLING DETAIL  
NOT TO SCALE

**D3189-3 CHAFING SHIELD**

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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